

Date: Friday, 23/05/2008 9:56:34 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 39444		
Estimate Number	: 10428		
P.O. Number	:	Part Number	: D32351
This Issue	: 23/05/2008 S.O. No. :	Drawing Number	: D3235 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 38927	Material	:
Written By	:	Due Date	: 15/06/2008 Qty: 200 Um: Each
Checked & Approved By	: <u>JULIE LECOCQ</u>		
Comment	: Est A 04.04.19 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)
 Lug Extrusion
 D2423 extrusion
 Batch: B33310

2.0	BAND SAW	BAND SAW
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Comment: Band Saw
 Cut D2423 extrusion to 0.820"
 Batch: _____

cut @ meter

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA369 and Dwg D3235
 2-Identify as D3235-1
 3-Deburr and Tumble

issue 7/0 6434 meter machine per dwg D 3235 REV. A

(200)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

reassure c/c/c attache

28/8/25 (200)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

inspect level 5

808/66/85 (200)

~~S.1 Tumble~~
~~S.2 QC5~~
 N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-07-07

200

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SOB 08/07/07 (x200)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M 107925

200

START TIME:

3:40

OVEN TEMPERATURE:

320°

FINISH TIME:

4:10

BR 08-07-08

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/07/09

200

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 471

AS 08/07/10 (x200)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



MF 08-07-10

Dart Aerospace Ltd

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Dart Aerospace Ltd

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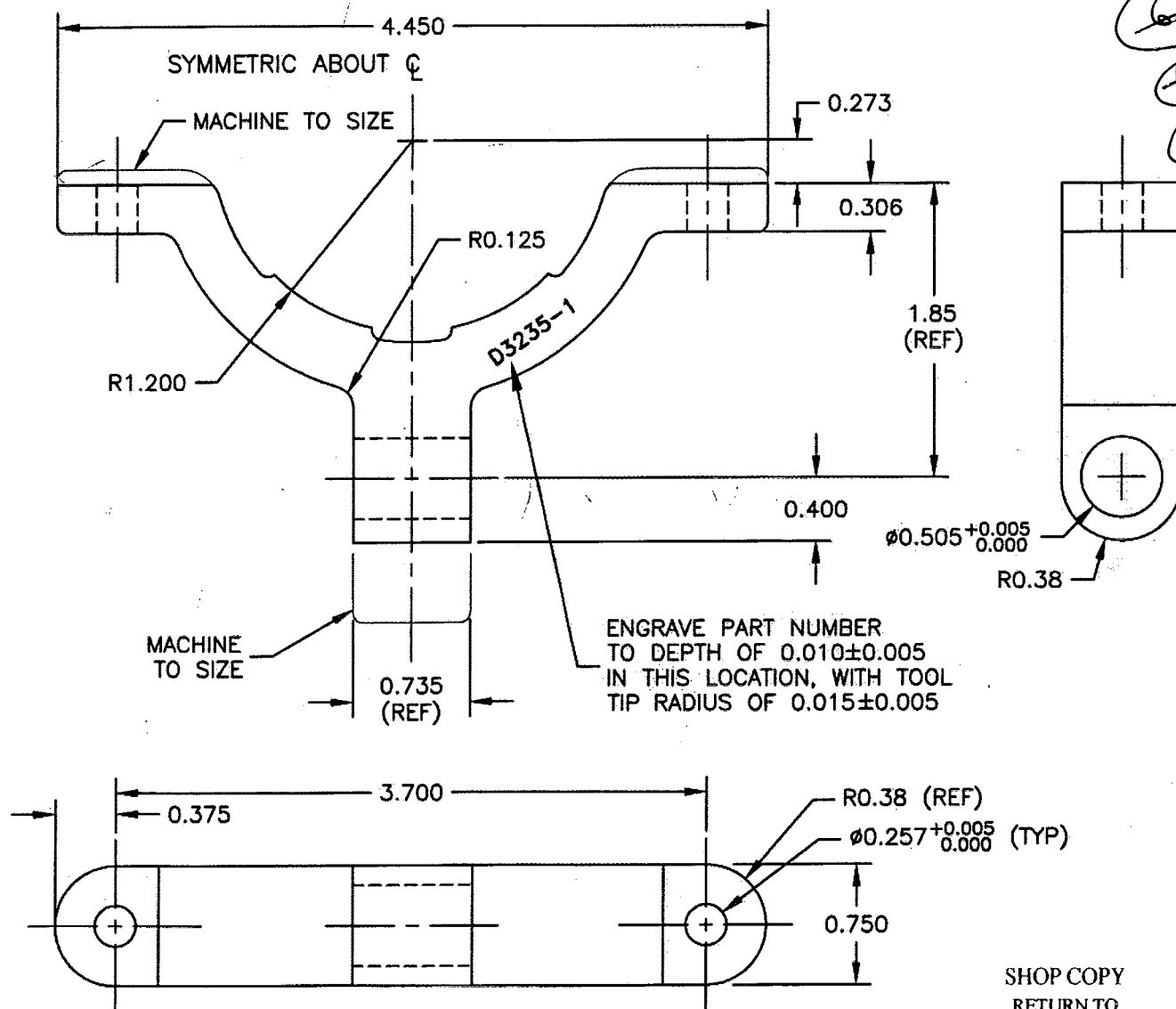
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39444

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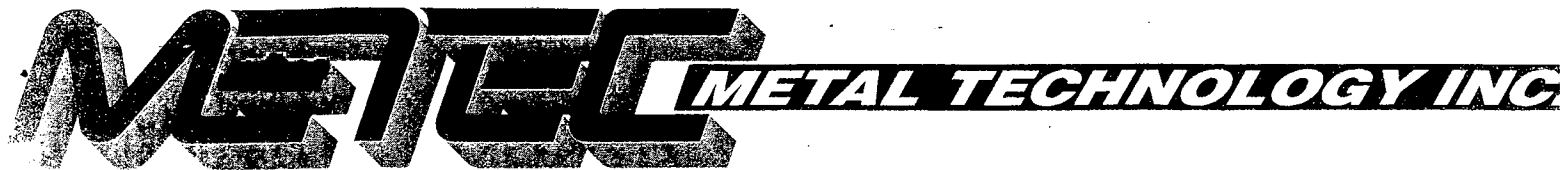
Dart Aerospace Ltd

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D3235-1

Mounting Lug

6434

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to be "D Denise", with a long horizontal line extending to the right.

Denise Robinson

Vankleek Hill, June 25, 2008